

Work Order ID 71628

Thursday, July 07, 2011 11:21:25 AM



Page 1

Item ID: D3259-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: Ymf Date: 11-07-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3259	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3259 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

7024.063

B11-8-12

(4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulloske

(X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

1-C'Sink Holes as per Dwg D3259

PS 11/08/15 (4)

140



Brake NC

NC BRAKE

0.00

Memo

0.00

Form as per Dwg D3259

SB 11/08/25

(4)

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/1/08/25

(49)
-3

Quality Control

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4X ~~SP~~ M-11/08/29

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/305P

180

Identify as per dwg & Stock Location: ST1809

0.00



Packaging

Memo

0.00

Packaging

SP

SP 11-08-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

u/8/30 
ME
11-08-30

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 11:21:23 AM

Page 1

Work Order ID: 71628



Parent Item: D3259-3



Parent Item Name: Doubler

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

250.3800

1.388

5.844211



B11-8-12

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

250.38

117018

25.88

117392

224.5

117392

4

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DART AEROSPACE LTD		Work Order: 71628
Description: Doubler		Part Number: D3259-3/-4
Inspection Dwg: D3259 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	8.999	L		PRO W 502	
1.000	+/-0.005	1.000	>		V BG2	
0.260	+/-0.010	.258	X		V	
R0.25	+/-0.030	.25	>		R.G	
R0.50	+/-0.030	.50	>		R.G	
5.000	+/-0.005	4.996	>		V	
0.875	+/-0.005	.873	>		V	
12.000	+/-0.005	11.999	>		P	
3.500	+/-0.005	3.498	L		V	
0.875	+/-0.005	.876	>		V	
R0.13	+/-0.030	.13	>		R.G	
0.500	+/-0.005	.499	>		V	
0.525	+/-0.005	.524	>		V	
1.80	+/-0.030	1.804	>		V	
Ø0.128	+0.005/-0.000	.129	>		V	
Ø0.377	+0.005/-0.000	.377	>		V	
Ø0.098	+0.005/-0.000	.102	>		V	
0.063 thick	+/-0.005	.063	>		V	
Grain Direction	N/A		>			

Measured by: PB	Audited by: S	Preliminary Approval:
Date: 11-8-12	Date: 11/02/12	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	
C	10.08.03	Dimensions updated	KJ	

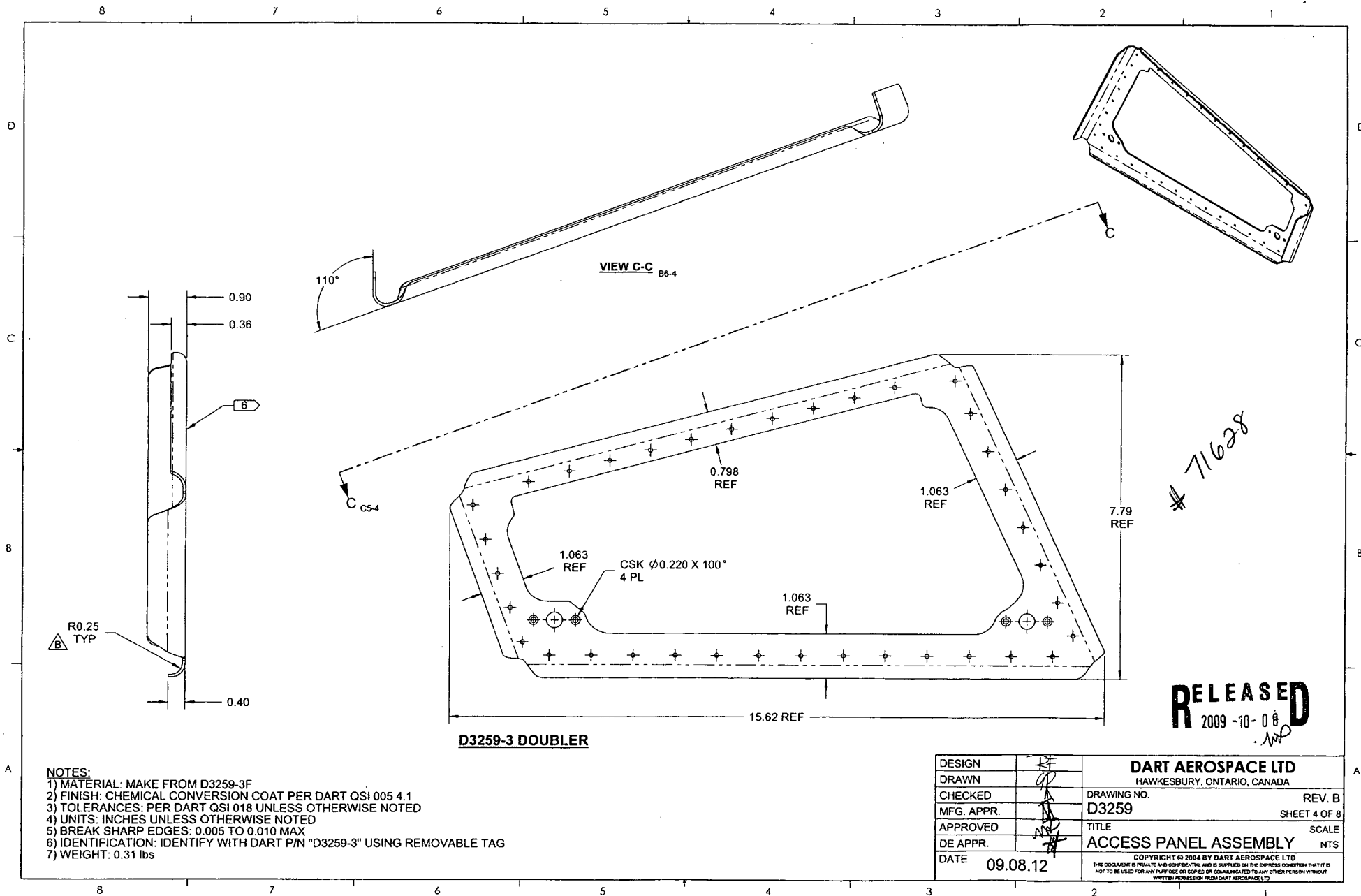
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